

# Work Order ID 74642

Tuesday, October 04, 2011 1:43:49 PM



Item ID: D4035-041

Accept



Setup Start



Revision ID:

Item Name: Lid Rib Assembly, Fwd (350 Basket)

Stop



Start Date: 10/4/2011 Start Qty: 200 6x



Cust Item ID:

Required Date: 10/11/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: M.L.J

Date: 11/10/04 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4035

A

100

Weld per dwg A/R S.S. rod Batch: M115778 0.00



Large Fab

Memo

0.00

Large Fab

- 1- Cut D4035-1 as per dwg D4035
- 2- Drill as per dwg D4035 using DT9562
- 3- remove identification marks and deburr
- 4- Weld bushing in rib as per dwg D4035

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

Pl 12.02.07

6x 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00							
130  Packaging Packaging	Identify as per dwg & Stock Location: _____  Basket cell Memo	0.00  0.00							
140  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							

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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, October 04, 2011 1:43:46 PM

Page 1

Work Order ID: 74642

Parent Item: D4035-041

Parent Item Name: Lid Rib Assembly, Fwd (350 Basket)

Start Date: 10/4/2011

Required Date: 10/11/2011



Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC  
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2327-3		Manufactured	No			100	Each	24.0000	1	2			
													
Spacer Bushing													

B77229 → 6x *by 12.02.07*

Location	Loc Qty	Loc Code
WA	24	
71971	1	
72296	3	
72963	20	

M304TS0.750W.049	Purchased	No				100	f	277.5873	1.75	3.684211			
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304 SQ Tube .75x.75x.049W



*M119643 by 12.02.07*

Location	Loc Qty	Loc Code
MAT018	203.1436839	
117775	98.2133	
118472	51.5848839	
118880	53.3455	
MAT034	1.8507	
117337	1.8507	
WA	72.59294	
118184	72.59294	

*11.04 + 1 END MATERIAL SCRAP*

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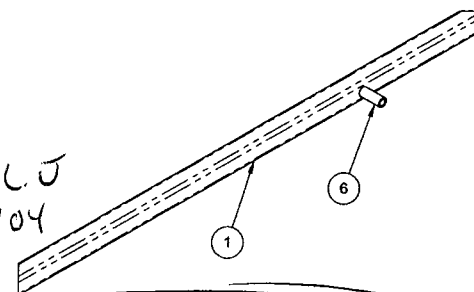
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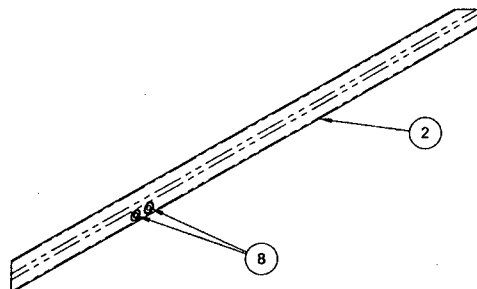
**NOTE:** Date & initial all entries

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING

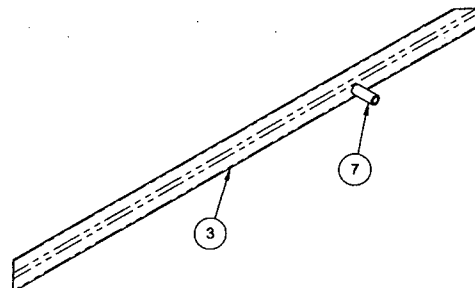
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RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 74642 M.C.J  
11/10/04



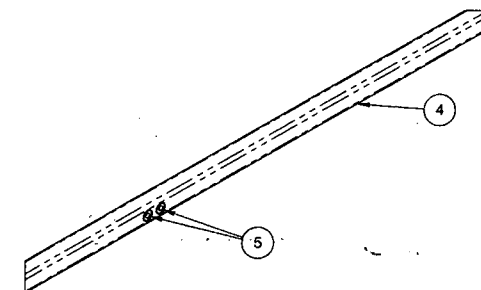
**D4035-041 BASKET LID RIB ASSY, FWD**



**D4035-043 BASKET LID RIB ASSY, AFT**



**D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)**



**D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)**

**RELEASED**  
2010-03-12

A	NEW ISSUE		JPH	10.03.04
REV.		DESCRIPTION	BY	DATE
DESIGN	AJS			
DRAWN	JPH			
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.03.04			

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D4035</b>	REV. A
TITLE <b>BASKET LID RIB ASSY</b>	SCALE NTS
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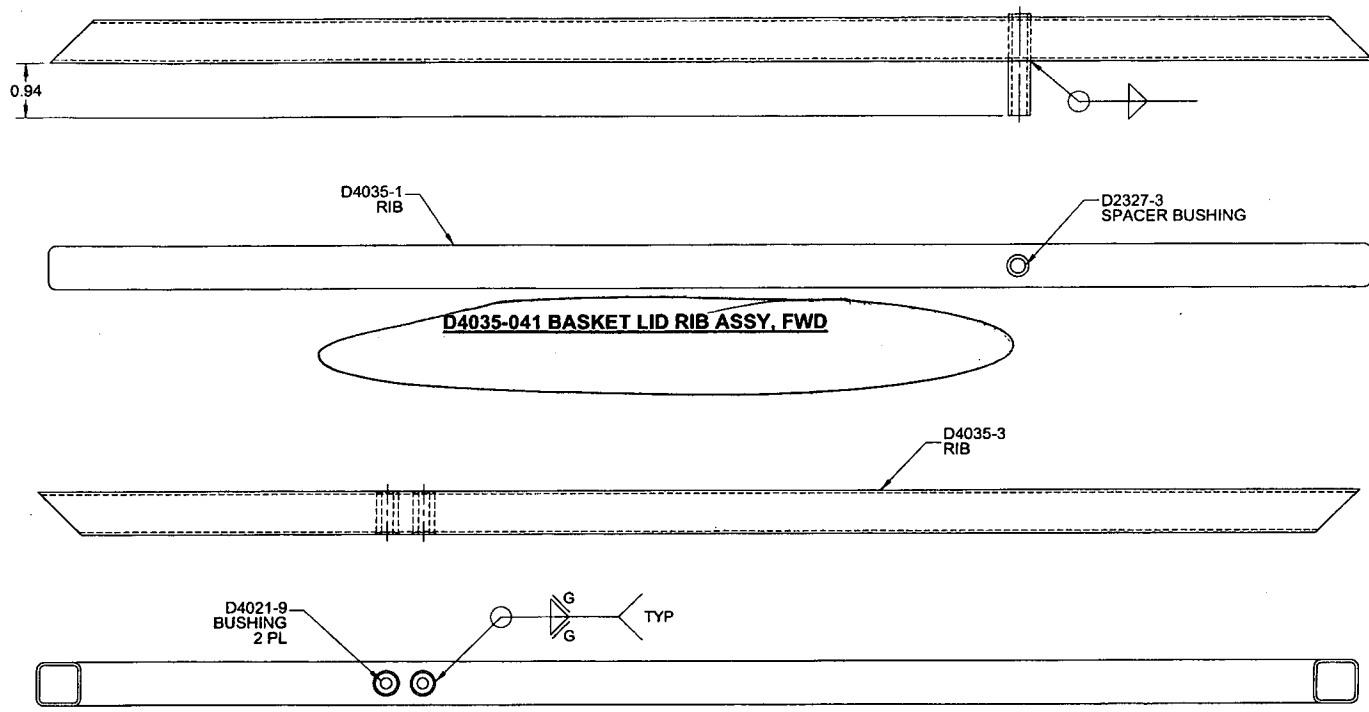
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**NOTE:** Date & initial all entries



74642



RELEASED  
2010-02-12  
MWD

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.83 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID RIB ASSY	NTS
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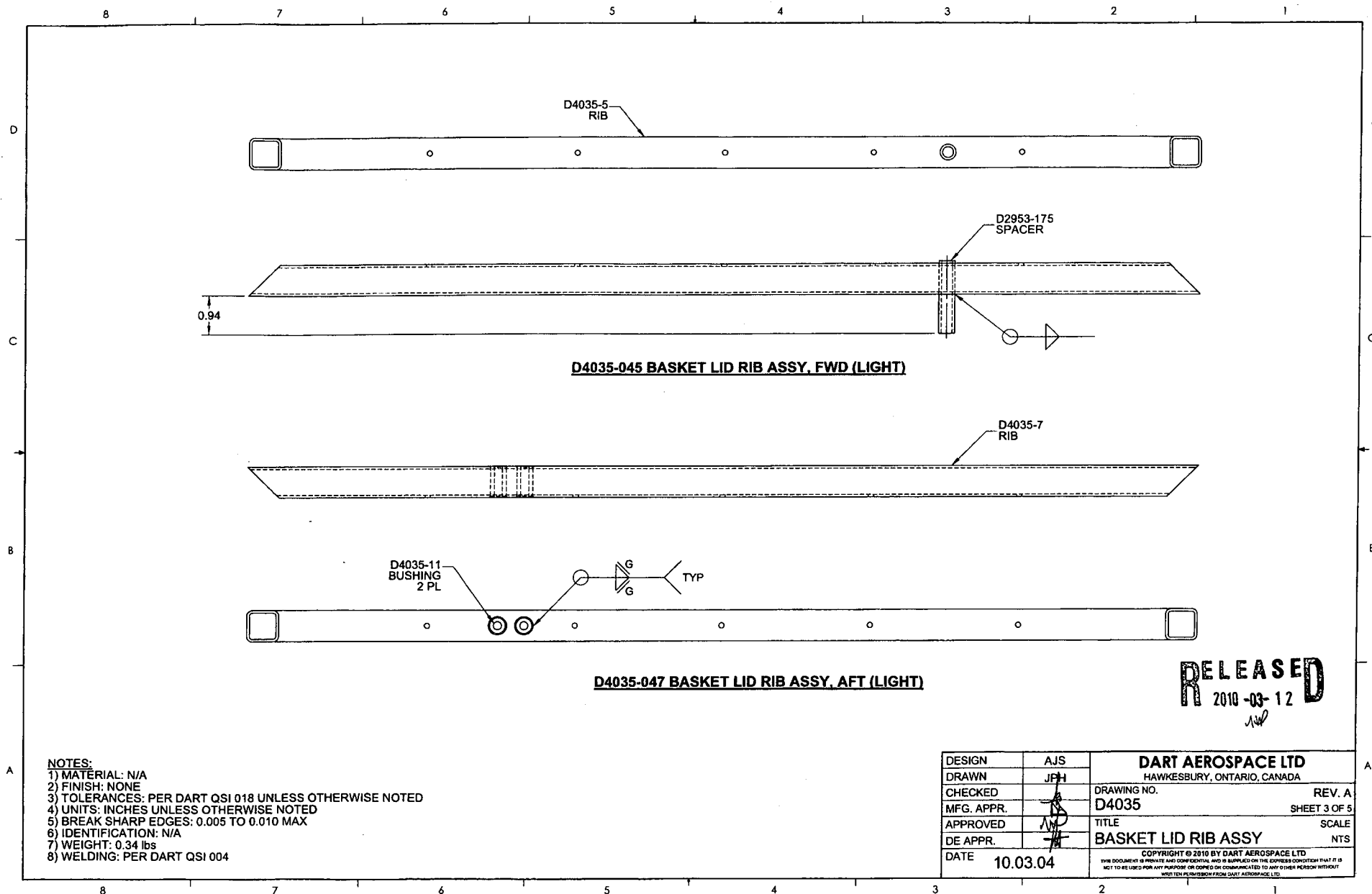
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**RELEASED**  
 2010-03-12  
*[Signature]*

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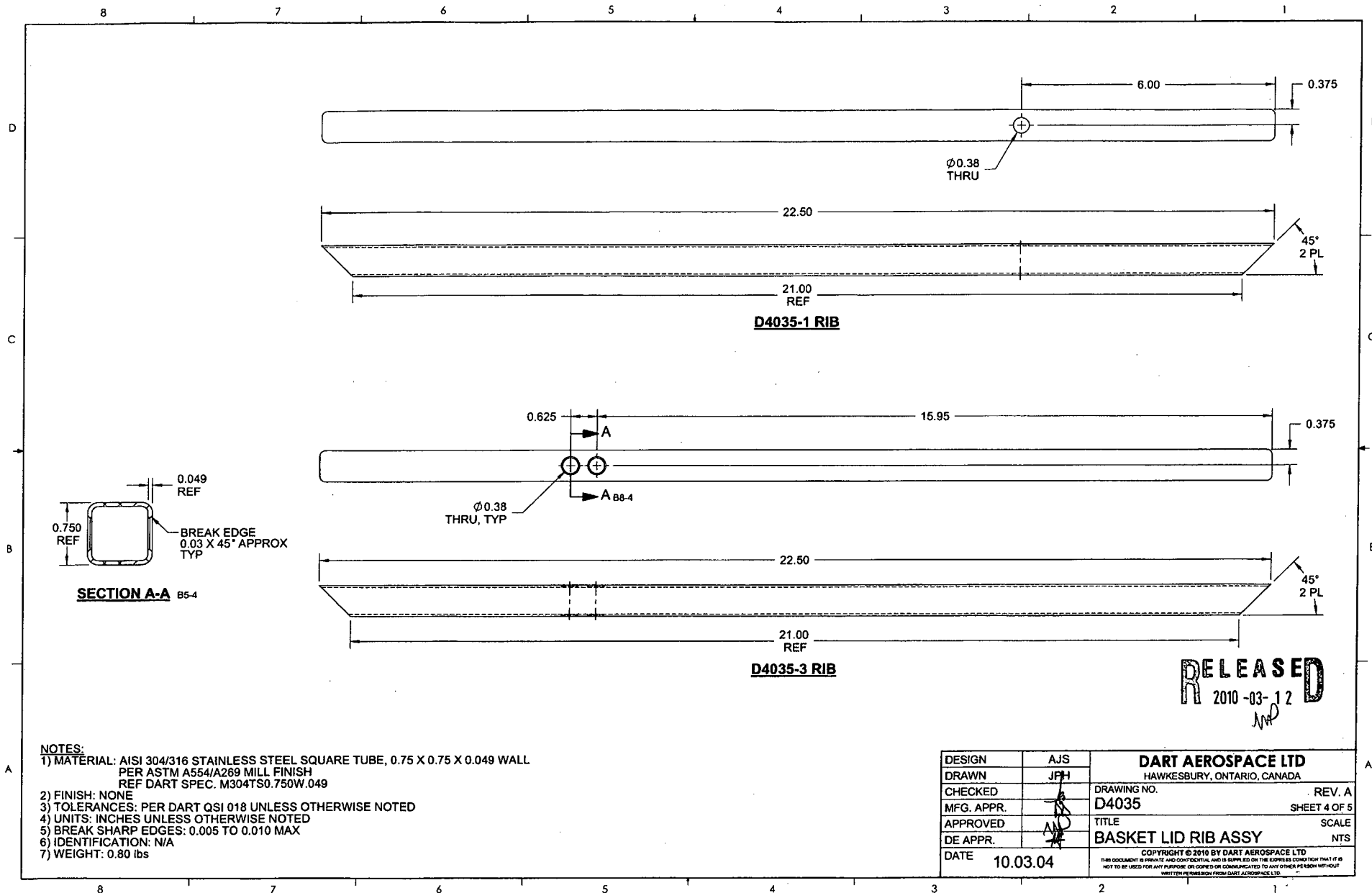
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74642



- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
PER ASTM A554/A269 MILL FINISH  
REF DART SPEC. M304TS0.750W.049
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.80 lbs

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 4 OF 5
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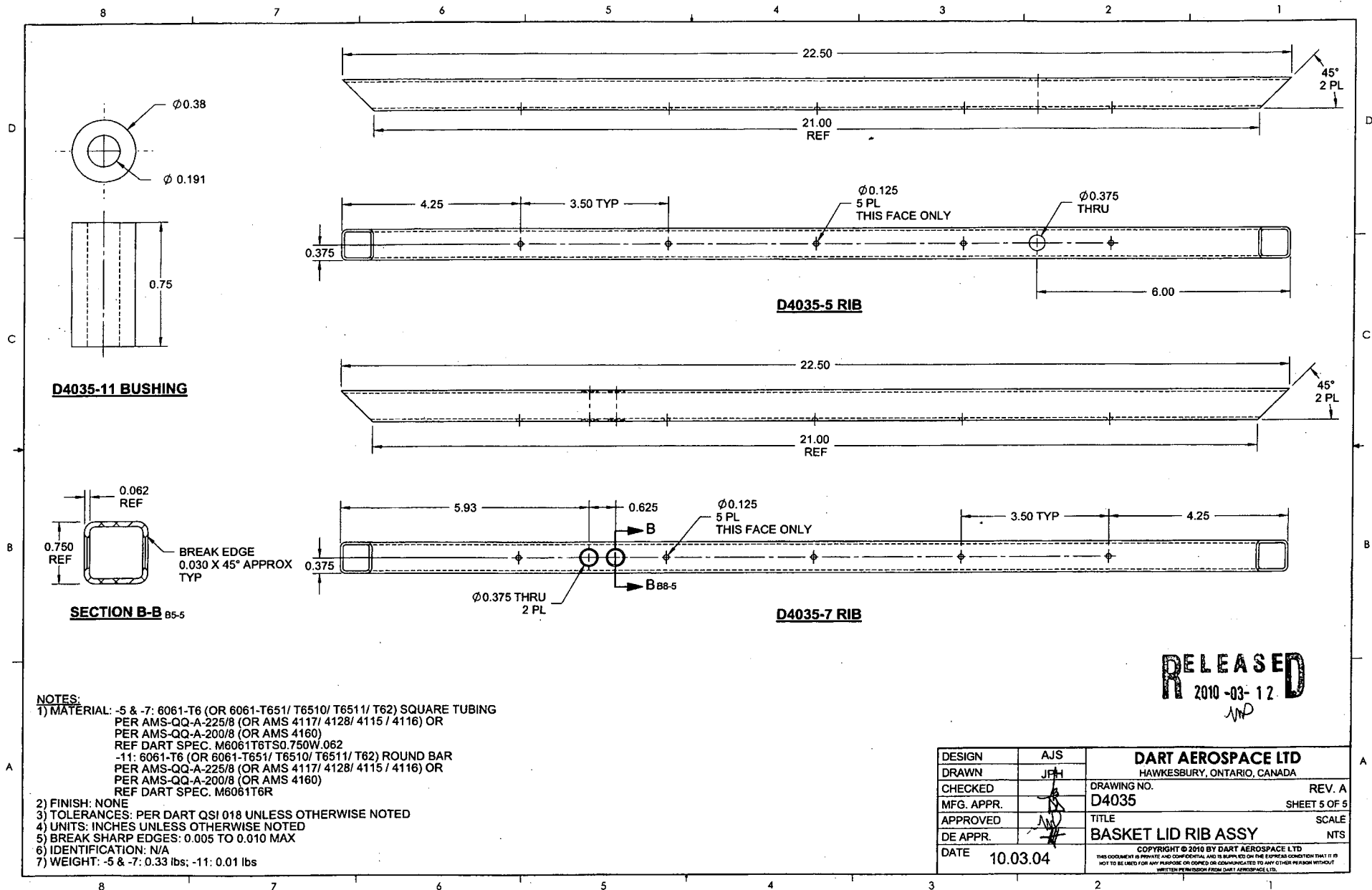
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